

Work Order ID 118437

118437

Page 1

Monday, September 08, 2014 1:14:11 PM

Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment
 Start Date: 8/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/26/2014 Req'd Qty: 1.00 ***1*** Customer: CEDWA01
 Reference: RMA RA111799

Approvals: Process Plan: mc Date: 14-9-8 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	F								
100		0.00							
100									
QC	Memo	0.00							
Quality Control	INSPECT RA 111799								
	D3562-041 X 1 B99339								
	REMOVE BOTH ARMS FOR TESTING								
110		0.00							
110									
QC	Memo	0.00							
Quality Control	QC21- Final Inspection - Work Order Release								

2 DMC 14-09-18
DAS
43
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Page 1

Monday, September 08, 2014 1:14:11 PM

Work Order ID: 118437

118437

Parent Item: D3562-041

D3562-041

Parent Item Name: Step Weldment

Start Date: 8/25/2014

Required Date: 8/26/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by:ec
IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3562-041		Manufactured	No				Each	0.0000		1			
D3562-041									**				
Step Weldment													

1 x 99339 MC

14-9-8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

RA 111799 D3562-041

B99339

Received @ Dart August 12th, 2014
Inspected @ Dart August 21st, 2014

CUSTOMER: BELL HELICOPTER TEXTRON INC
CUSTOMER CONTACT: JAMES COULSON
SHIPPED FROM: PINEY FLATS, TN, USA

Instructions for RA 111799 D3562-041 B99339

- D3560-041 is cracked see attached pictures
- Remove both arms for testing

Time Estimate = ? HOURS

Departments Required: Quality control

Pictures Attached = yes

QTY INSPECTED = x1 D3562-041

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Set-up
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

RA 111799 D3562-041

B99339

Received @ Dart August 12th, 2014
Inspected @ Dart August 21st, 2014

CUSTOMER: BELL HELICOPTER TEXTRON INC
CUSTOMER CONTACT: JAMES COULSON
SHIPPED FROM: PINEY FLATS, TN, USA

Instructions for RA 111799 D3562-041 B99339

- D3560-041 is cracked see attached pictures
- Remove both arms for testing

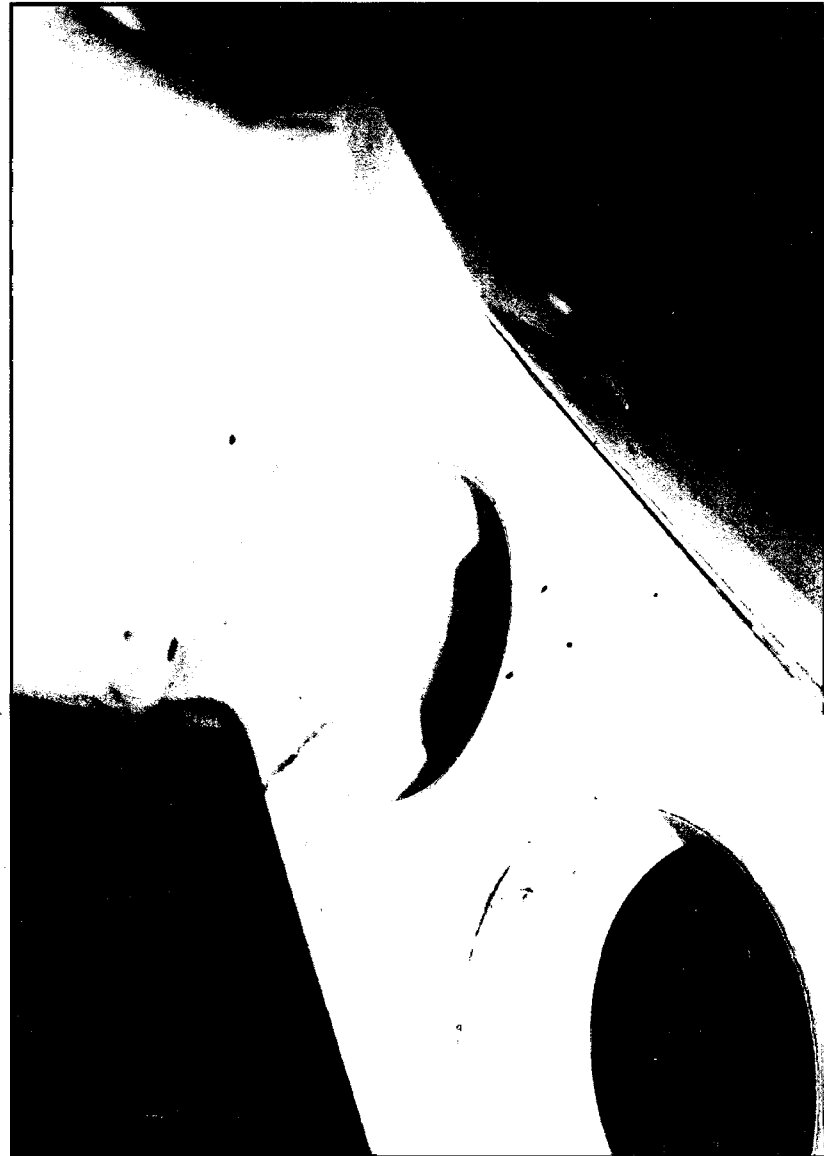
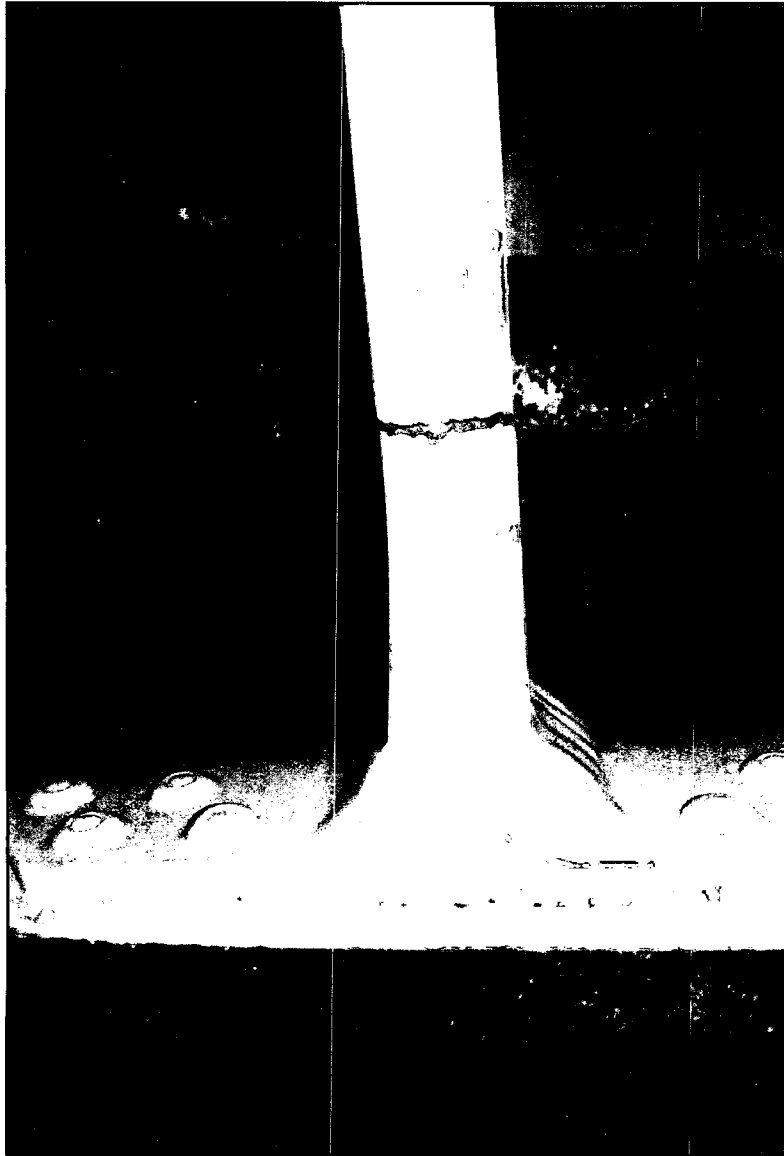
Time Estimate = ? HOURS

Departments Required: Quality control

Pictures Attached = yes

QTY INSPECTED = x1 D3562-041

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**







1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

RETURN AUTHORIZATION

Date: 2-Jun-14
Customer Name: Bell Helicopter Textron Inc.
Customer Code: CEDWA01
Telephone No: 817-280-1557
E-mail Address: jacoulson@bh.com
Contact Name: James Coulson
Issued by: Jennifer Renwick

DART RA Number: RA111799
Customer-Supplied: ☐ Trial/Test ☐
Sales Order Generated: SO111477 (SO6614)
OEM Initiated & Chase:
Approved by: SW
DART Invoice #: INV111477(IN6595)
PAR/CAR/NCR/SQ: NCR14-3915

Quantity	Part Number	Description	Batch Number	Customs Value (ea)
1	D3562-041	Step Weldment	B99339	\$3,300

Reason for Return: Customer reports cracked D3560-041 in unusual location. Step shows no signs of misuse or damage. Could be due to material defect. See attached report from customer.

Credit Instructions:

☐ Credit
☒ None

Return Instructions: Commerical Invoice Yes
Documentation (STC/ARC/ICA) Yes
Packing Slip Yes
Include on Commerical Invoice:
Part Number/Description/Value in USD
Parts are aircraft parts/return to Manufacturer

Shipping Instructions: Prepaid _____ Collect YES _____ Courier _____ Fed-ex _____
Account # _____ DART

RECEIVING RETURN AUTHORIZATION

Receiver: SP Condition of Packaging: Endomager Photograph Required
Date Received: 14-8-12 Freight Company: Fedex Yes No

Quantity	Part Number	Batch	QC Verification	CHG #	W/O#	Disposition
1	D3562-041	99339	3119952			

QC Inspector: Photograph Attached Condition:
Date: Yes No Sealed Complete Short H/W Short Kit No P/W Damaged

QC Comments: **Special Return/Rework Instructions:** QC needs to inspect and determine the cause of the crack

Issue Credit: Yes No

Credit Invoice Amount: 0

Credit Note: _____

Restocking Fee: _____

Approval: _____

Date: _____

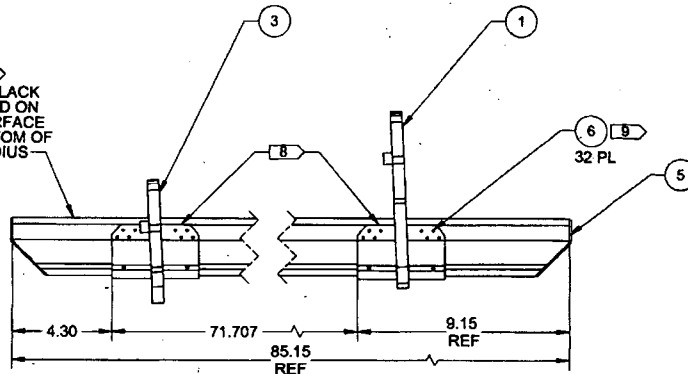
Freight: _____

Net Credit: _____

Closed by: _____

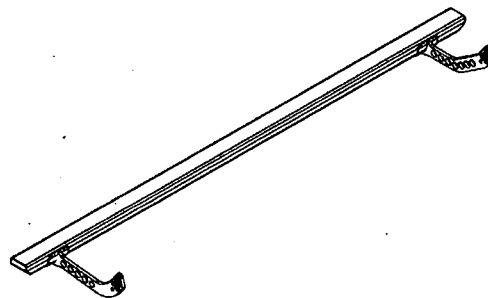
Close Date: _____

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM OF
TOP RADIUS



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



D3562-041 LH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

- i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.8) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

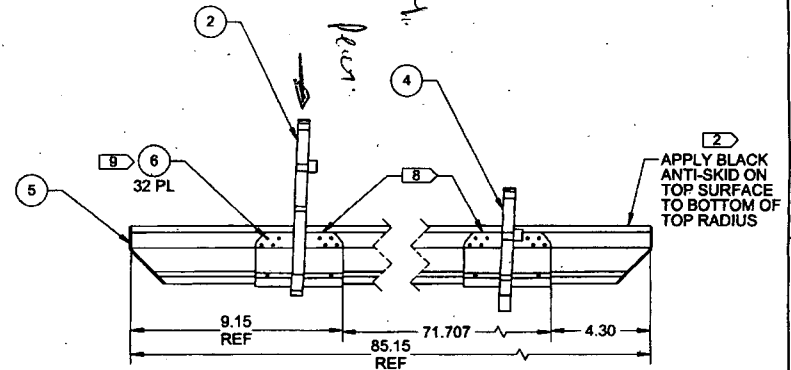
7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

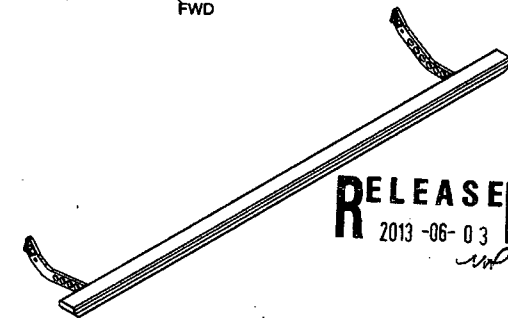
ITEM No.	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3562-041	LH STEP ASSEMBLY
		X	D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS20600AD4W5	RIVET

Remove both arms
HAWKESBURY
APPROX + SANDTEX PER



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



D3562-042 RH STEP ASSEMBLY

REV.	DESCRIPTION	BY	DATE
F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.18
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.05.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3562

TITLE
STEP ASSEMBLY

REV. F
SHEET 1 OF 2
SCALE
NTS

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8 7 6 5 4 3 2 1

D

C

B

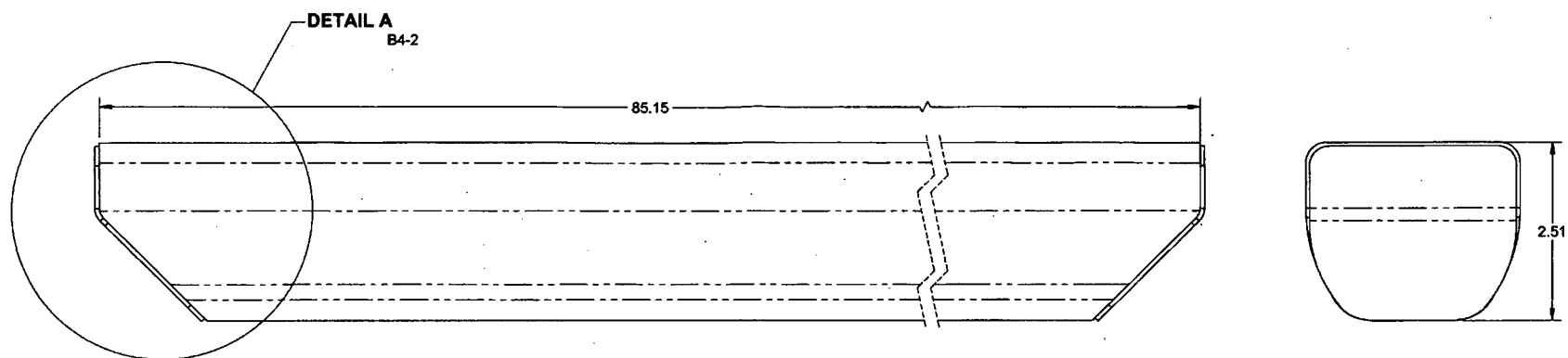
A

D

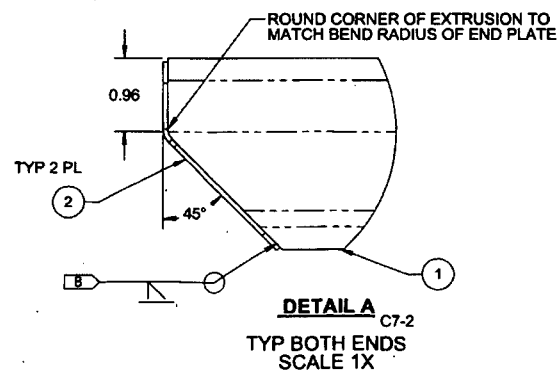
C

B

A



D3562-1 STEP ASSEMBLY



RELEASED
2013-06-03
WIP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
BY A QUALIFIED INSPECTOR PER DART QSI 004

ITEM No.	QTY	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE

DESIGN	UP	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. F
MFG. APPR.	WIP	D3562	SHEET 2 OF 2
APPROVED	WIP	TITLE	SCALE
DE APPR.	WIP	STEP ASSEMBLY	NTS
DATE	13.05.15	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COPYRIGHTED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1